

What is claimed is:

1. A dynamo-electric machine's winding producing method, in which a plurality of electric conductors respectively having insulating coats on surfaces thereof are received
5 in each of a plurality of slots formed in a stator core in a line along a circumferential direction of the stator core so as to form a plurality of coil ends of the electric conductors when portions of the electric conductors protruded from an end surface of the stator core are bent
10 in the circumferential direction of the stator core, the method comprising the steps of:

forming a first copying surface in a slot opening forming cut of each slot arranged on the end surface of the stator core so as to be curved along a bending direction
15 of the corresponding electric conductors;

forming a second copying surface on a bending member inserted into an area between two groups of coil ends of the electric conductors of the two slots adjacent to each other in the circumferential direction for each pair of
20 slots adjacent to each other so as to be curved along the bending direction of the corresponding electric conductors; and

bending each of the electric conductors along a successively-curved shape formed out of both the
25 corresponding first copying surface and the corresponding second copying surface.

2. The dynamo-electric machine's winding producing method according to claim 1, wherein each electric conductor
30 is bent along the corresponding first copying surface and

the corresponding second copying surface in the step of bending each of the electric conductors in a condition that the corresponding bending member is in contact with the end surface of the stator core.

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3. The dynamo-electric machine's winding producing method according to claim 1, wherein each first copying surface is a portion of a curved surface formed on the corresponding slot opening forming cut, each second copying
10 surface is a curved surface formed on a surface of the corresponding bending member, and a curved surface of the successively-curved shape is larger than a combination of the corresponding first copying surface and the corresponding second copying surface.

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4. The dynamo-electric machine's winding producing method according to claim 1, further comprises the step of bonding the coil ends of the electric conductors together so as to produce a winding from the electric conductors.

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5. The dynamo-electric machine's winding producing method according to claim 1, wherein each electric conductor received in each slot is connected in advance to the other electric conductor received in the other slot on a side
25 of another end surface of the stator core so as to produce a winding from the electric conductors.

6. The dynamo-electric machine's winding producing method according to claim 1, wherein each bending member
30 is formed in a skewer shape.

7. A dynamo-electric machine's winding producing method, in which a plurality of electric conductors respectively having insulating coats on surfaces thereof are received
5 in each of a plurality of slots formed in a stator core in a line along a circumferential direction of the stator core so as to form a plurality of coil ends of the electric conductors when portions of the electric conductors protruded from an end surface of the stator core are bent
10 in the circumferential direction of the stator core and to position and bond tops of the electric conductors together, the method comprising the steps of:

forming a first copying surface in a slot opening forming cut of each slot arranged on the end surface of
15 the stator core so as to be curved along a bending direction of the corresponding electric conductors and so as to intersect with the end surface of the stator core;

forming a second copying surface and a third copying surface on a bending member inserted into an area between
20 the two groups of coil ends of the electric conductors of the two slots adjacent to each other in the circumferential direction for each pair of slots adjacent to each other so as to make an extended surface of the second copying surface come in contact with an intersection point of the
25 corresponding first copying surface and the end surface of the stator core and so as to place the third copying surface further away from the end surface of the stator core than the second copying surface;

bending the electric conductors along the first copying
30 surfaces;

making the electric conductors come in contact with the second copying surfaces;

bending the electric conductors along the third copying surfaces;

5 returning the electric conductors to positions, at which the electric conductors extend along the second copying surfaces, due to spring back of the electric conductors; and

10 bonding the electric conductors together so as to produce a winding from the electric conductors.